

Work Order ID 69622 - 1

Thursday, May 12, 2011 3:16:31 PM

Page 1

Item ID: D2600-1-190

Accept

Revision ID:

Item Name: Extrusion Round 3" 206

Start Date: 5/12/2011 Start Qty: 40.00

Required Date: 5/16/2011 Req'd Qty: 40.00

Reference:

Approvals:

Process Plan:

Date: 11/05/13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2600

Rev D1

100

0.00



Purchasing

Purchasing

PURCHASING

Memo

0.00

Issue P/O: 44089 ☐ a) Extrude as per Dwg D2600 (190" long) ☐ b)  
Material: 6061-T6 ☐ c) Bon L die # 897121 ☐ d) Material certification is  
required.

CL 11/05/13 (70)

110

0.00



Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

0.00

Ensure material certification is attached

11/17/25 (59)

120

0.00



QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

11 07 26 (59)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Thursday, May 12, 2011 3:16:37 PM

Page 1

Work Order ID: 69622



Parent Item: D2600-1-190



Parent Item Name: Extrusion Round 3" 206


Start Date: 5/12/2011

Required Date: 5/16/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A 99.08.18 Was 2600-1 added -240 for length EC  
IPP Rev.B 07.02.28 Changed length to -190 LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-1-190P  Extrusion Round 3" 206		Purchased	No			110	Each	0.0000	1	4070		5/17/25	(59)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
D1	01-04-17	ADD PART NUMBERS + DIE NUMBERS <i>FCP</i>	

RELEASED  
98.08.25 DS

#### GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi  
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED  
TO ASTM STANDARD B221 BY AN APPROVED TESTING  
FACILITY TO ENSURE THAT THE BATCH MEETS THE  
ABOVE MINIMUM MECHANICAL PROPERTIES.

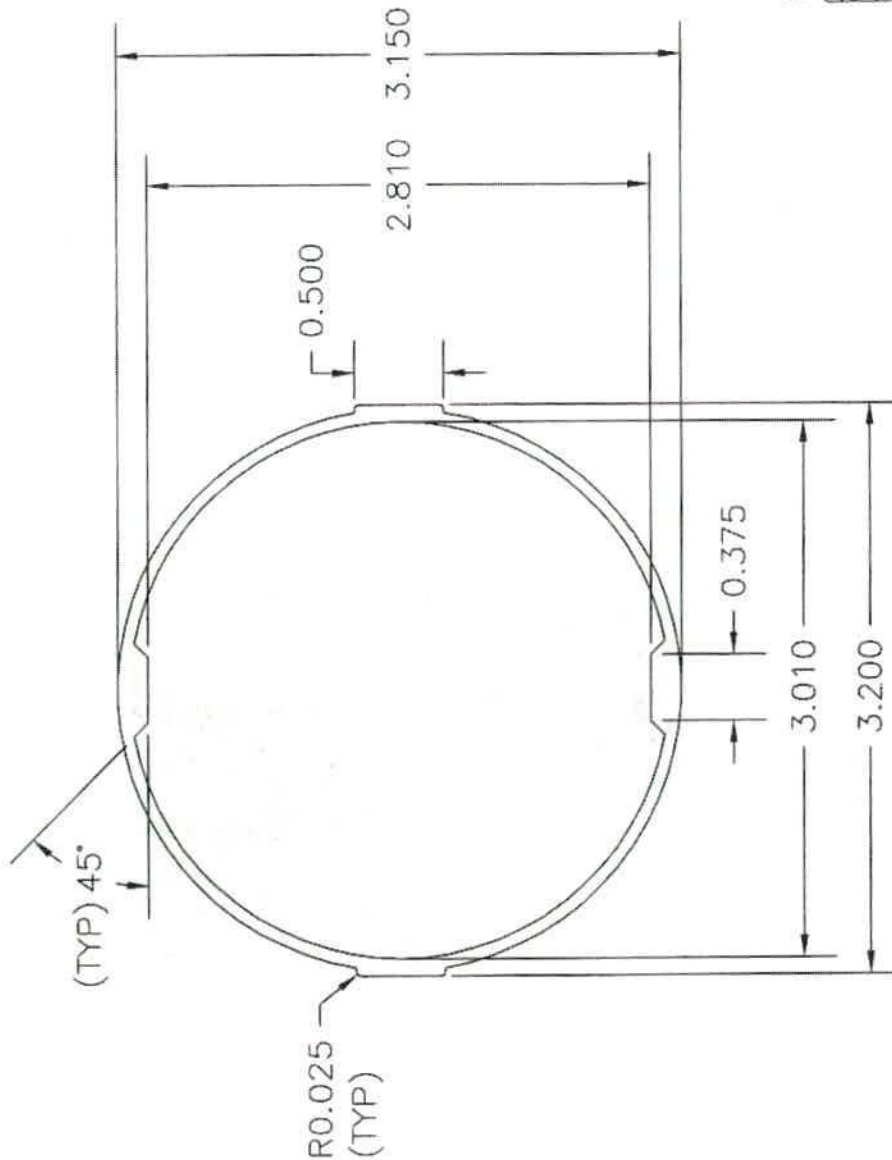
2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE  
NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

**DART**



DESIGN <i>DD</i>	DRAWN BY <i>DD</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>DT</i>	DRAWING NO. D2600	REV. D SHEET 2 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

**RELEASED**  
98.8.25 DS



D2600-1

MANUFACTURED WITH CARADON INDALOX DIE # MH-18870

OR BON L DIE # 897121 (PREFERRED CHOICE)

PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 16.0" LONG)

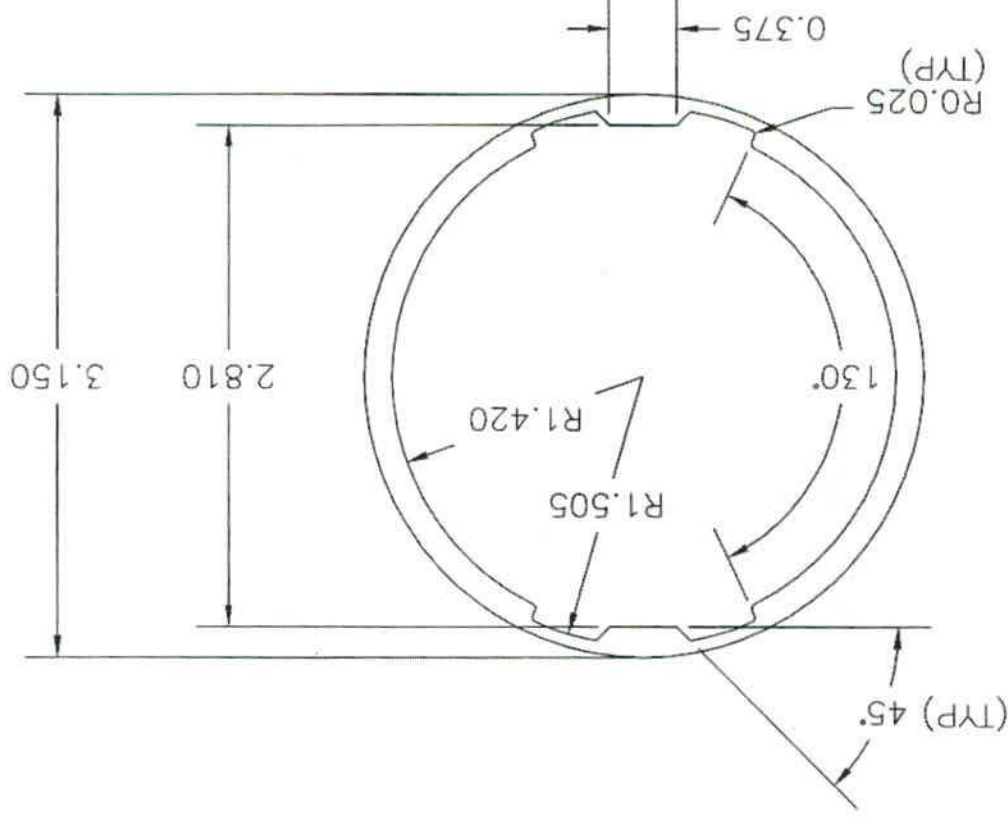
$\Delta_{bi}$





DESIGN		DRAWN BY	DART AEROSPACE LTD	
CHECKED		APPROVED	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA
DATE			D2600	
98.08.20			TITLE	
			EXTRUSION	
			SCALE	1:1
			SHEET 3 OF 5	REV. D

RELEASED  
98.8.25 DS

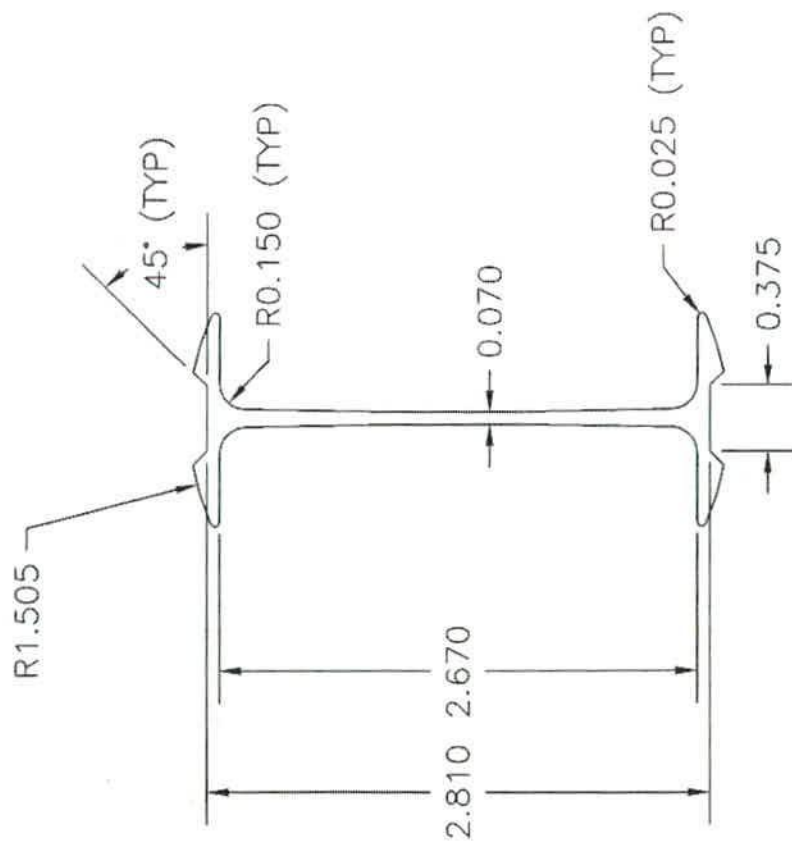


D2600-3  
MANUFACTURED WITH CARADON INDALEX DIE # MH-18859  
OR BON L DIE # 897122 (PREFERRED CHOICE)  
PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-3-120 IS 120" LONG)



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D SHEET 4 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED  
98.8.25 DS



D2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871

PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES  
(EG. D2600-5-108 IS 108" LONG)

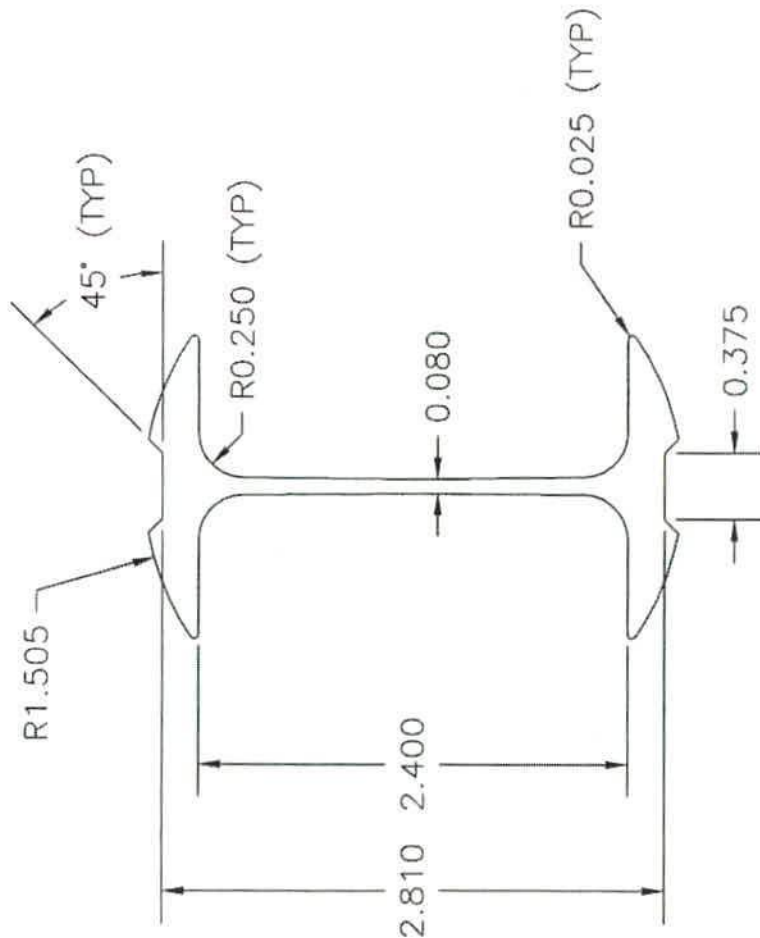


**DART**



DESIGN <i>RA</i>	DRAWN BY <i>RA</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>AS</i>	DRAWING NO. D2600	REV. D SHEET 5 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

**RELEASED**  
98.8.25 DS



D2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872  
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES  
(EG. D2600-7-125 IS 125" LONG)





Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

\*\*\*PO REPRINT\*\*\*

Purchase Order ID PO14089

Purchase Order Date 5/13/2011

PO Print Date 5/13/2011

Page Number 1 of 1

Order From :

VC-BON001

SIGNATURE ALUMINUM  
1850 CLEMENTS ROAD  
PICKERING, ON L1W 3R8  
CA

Contact Name  
Vendor Phone 800 563 1079  
Vendor Fax 800 565 8339  
Vendor Account Nbr

Buyer Chantal Lavoie  
Requisition Nbr  
Tax Resale Nbr 10127-2607  
Terms Net 30  
Currency CAD  
FOB Destination-Collect

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

FAKED  
CL 11/05/13

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2600-1-190P ✓	Extrusion Round 3" 206	7/15/2011 Yes	70.00 Each		\$48.5890	\$3,401.23

Special Inst: EXTRUDE AS PER DWG D2600  
REV.D1  
B69622  
✓ MATERIAL: 6061-T6 AS PER QQ-A-  
200/8  
MINIMUM YIELD TENSILE  
STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE  
STRENGTH = 40 KSI  
MINIMUM ELONGATION = 8%  
PULL TEST TO ASTM STANDARD  
B221

Net 55 1617/05

PO Total: \$3,401.23

PO Instructions: PLEASE ONLY FOR JULY 15

≡

WCL

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

Change Nbr: 2

Change Date: 5/13/2011



ACCT# 46024

INVOICING AND COMPANY LOCATION

SIGNATURE ALUMINUM CANADA  
1850 CLEMENTS ROAD  
PICKERING ON L1W 3R8

SHIPPING MANIFEST

MANIFEST DATE / DATE DU BODEREAU  
07-24-11

MANIFEST NUMBER / N° DE BODEREAU  
001977

SALES ORDER NUMBER / N° DE COM  
101238

SHIP TO / EXPÉDIÉ À

DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7  
CANADA

PHONE: 613-632-5200

SOLD TO / VENDUE À

DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7  
CANADA

PHONE: 613-632-5200

TERMS / FREIGHT

PP

REFER TO  
THESE NUMBERS ON  
ALL CORRESPONDANCE

REFEREZ-VOUS A CES  
NUMEROS POUR TOUTE  
CORRESPONDANCE

LOCATION	TRAILER NUMBER / REMORQUE Nombre	SALESMAN / VENDEUR	CREDIT REP / REP DU CRÉDIT	SALES REP / REP. DES VENTES
PIC	5301	138		H. CAMERON
JOB / FICHIER	CARRIER / TRANSPORTEUR	FIELD SALES REP / REP REGIONAL DES VENTES	CUST SERVICE REP / REP. SERVICE CLIENTELE	
	JODEE	M. BATES	cgerard	

ITEM NO. / NUMÉRO	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	UNIT / UNITÉ	PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée	MFG. PART NUMBER / MFG. PARTIE NUMÉRO	ALLOY & TEMPER / ALLIAGE & TEMPER	FINISH DESCRIPTION / DESCRIPTION DE FINITION	NBR OF PKGS / NBR DE PKGS	GROSS LBS / LIVRES BRUT	NET QUANTITY / QUANTITÉ NETTE	UNIT / UNITÉ	QUANTITY DUE / Quantité en raison
001	1,109	LB		DAA-897121-3	6061 T6		2	928	888	LB	
	503	KG		D2600-1-190	190.0000 IN			421	403	KG	
	70	PC			Cut(+): 0.0000 Cut(-): 0.0000 Min: 0 % Max: 0 %				59	PC	
						803046 / 112723	1	606	586		39 PC
						803046 / 112724	1	322	302		20 PC

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.  
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

Page 1

DATE OF DELIVERY

DRIVER

2	928	888	LB
	421	403	KG
		59	PC
TOTALS			

59

## CERTIFICATE OF COMPLIANCE

## SIGNATURE ALUMINUM CANADA

1850 CLEMENTS RD  
PICKERING, ON L1W 3R8

Cert Date	Cert No.	Sales Order	Page
07/19/2011	5265668	101238	1
Cust PO	B/L No	Lot	Date
14089	001977	803046	07/24/11

Sold To

Ship To

46024  
DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7  
CANADA46024  
DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7  
CANADA

Item No	Part No	Item Description	Cust Part
001	DAA-897121-3	190" Mill 6061 T6	D2600-1-190
Gross Weight	928 LBS		
Net Qty	888 LBS	59 PCS ✓	2 PKGS
Specification	AMS QQA 200/9 + ASTM B221-08		Die Desc

Mechanical Tests:

Tensile	Yield			
MPA / KSI	MPA / KSI	% Elongation	Conductivity	HREW
309.0 / 44.8	272.4 / 39.5	11.0	0.0	93

Chemical Analysis:

SI	FE	CU	MN	MG	CR	ZN	TI	V
0.67	0.25	0.25	0.08	0.91	0.06	0.08	0.02	0.01

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

R. Petersen, QA Manager Signature Aluminum Canada Inc